

Work Order ID 56904

March 12, 2010 1:26:29 PM



Page 1

Item ID: D3695-1

Accept



Setup Start



Revision ID:

Item Name: Slider

Stop



Start Date: 12/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *H*

Date: *10-3-12* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3695	Rev C								
100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 9.450" long								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA739 Rev: <i>C</i> & Dwg D3695 Rev: <i>C</i> 2-Deburr per dwg D3695 3-Manually Tap for 10-32 heli coil								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

HA 10/03/15

4

0

HA 10/03/15

4

0

HA 10/03/15

4

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56904

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

DT 10/03/17

4 0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

=> MJ 10/03/16

(x4) 0

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M112588

Memo

0.00

=> MJ 10/03/22

(x4) 0

Powder Coating

****mask threaded holes & un-hatched area as per dwg****

START TIME: 7:30 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:00 AM

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Page 3

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

m-l 10/03/23

(4X)

170

Identify as per dwg & Stock Location: *56890*

0.00

Packaging

Memo

0.00

Packaging

m-l 10/03/23

(4X)

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/23
MF
10-3-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March 12, 2010 1:26:33 PM

Page 1

Work Order ID: 56904

Parent Item: D3695-1

Parent Item Name: Slider

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM IPP rev B
10.02.03 as per ncr 10-015 EC verified by: JLM

Start Date: 12/03/2010

Required Date: 26/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061-T6 Bar 2.00 x 1.25 0		Purchased	No			100	f	9.3655	3.3617			



6061-T6 Bar 2.00 x 1.25



2.5 x 1.5 4-10-03-15
1.500 x 02.500
This Batch only

Warehouse	Loc Qty	Loc Code
Main Warehouse		
MAT	9.365468421	
105838	6.9124	
110936	0.00036842	
113608	2.4527	
<u>107387</u>		

3.1666^{ft} H.A 10/03/15

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	56904
Description: Slider		Part Number:	D3695-1
Inspection Dwg: D3695 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+0.000/-0.010	0.997	✓			
0.500	+/-0.010	0.496	✓			
0.300	+/-0.010	0.300	✓			
0.485	+0.000/-0.010	0.4835	✓			
2.000	+0.000/-0.010	1.993	✓			
8.750	+0.005/-0.000	8.752	✓			
Ø0.386	+0.006/-0.001	Ø0.389	✓			
Ø0.203	+0.005/-0.001	Ø0.207	✓			
0.738 deep	+/-0.010	0.738	✓			
0.500	+/-0.010	0.498	✓			
0.450	+/-0.010	0.450	✓			
2.025	+/-0.010	2.025	✓			
0.675 pitch	+/-0.010	0.675	✓			
1.075	+/-0.010	1.075	✓			
R0.25	+/-0.030	R0.250	✓			
0.13 x 45°	+/-0.030 x 0.5°	0.133 x 45°	✓			
0.900	+/-0.010	0.900	✓			
9.25	+/-0.030	9.250	✓			
0.50	+/-0.030	0.519	✓			
0.875	+/-0.010	0.874	✓			
0.310 deep	+/-0.010	0.310	✓			
4.75	+/-0.030	4.746	✓			
1.06	+/-0.030	1.054	✓			
1.000	+/-0.010	0.998	✓			

Measured by:	B.A	Audited by:	DTJ	Prototype Approval:	N/A
Date:	10/03/15	Date:	10/03/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	M

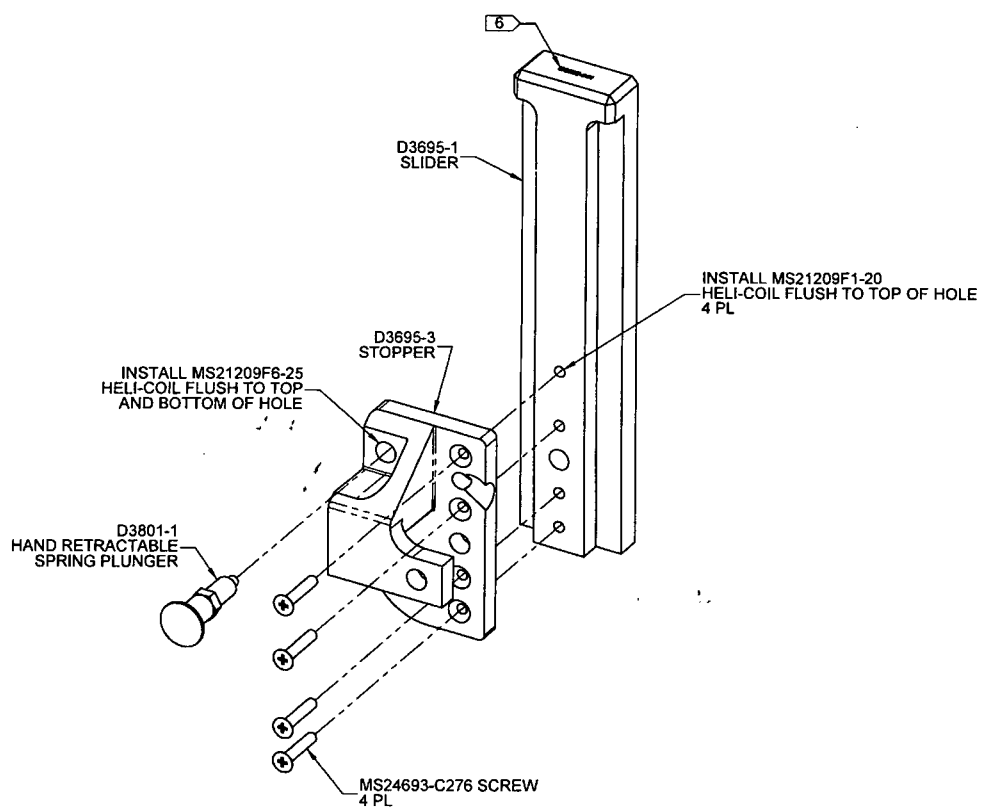
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NOTE: Date & initial all entries



D3695-041 SLIDER ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
1	X	D3695-041	SLIDER ASSEMBLY
11	1	D3695-1	SLIDER
12	1	D3695-3	STOPPER
15	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
21	4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
22	1	MS21209F6-25	HELI-COIL, SCREW LOCKING (RED)
23	4	MS24693-C276	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36909
PL-10-3-12

RELEASED
9/62/65 JH

C	UPDATED BOM TO CURRENT STANDARDS; REVISED ITEM 12 (ZN D3-1); DIMS 1.83 AND 1.075 ^{±.005} WERE 1.81 AND 1.063 ^{±.005} (ZN B8-3 AND C4-3). REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN	LB		
DRAWN	LB		
CHECKED	PH		
MFG. APPR.	SH		
APPROVED	SH		
DE APPR.	SH		
DATE	08.11.04		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3695 REV. C SHEET 1 OF 3 TITLE SLIDER ASSEMBLY SCALE NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

D3695-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3695-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: D3695-041 = 0.64 lbs

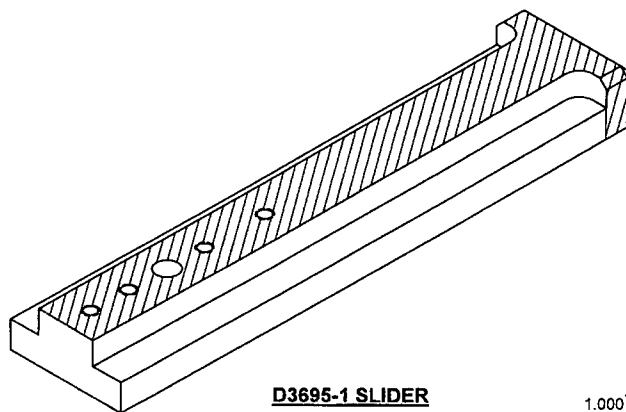
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

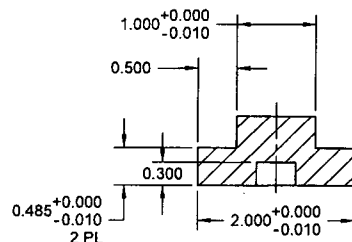
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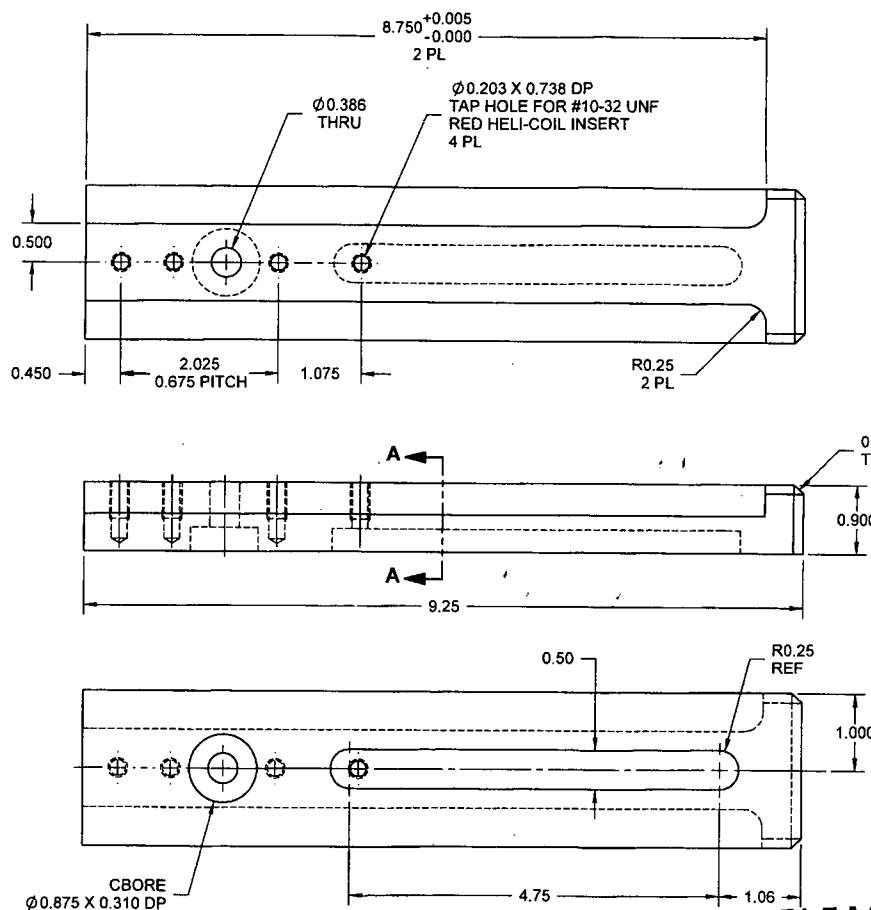
NOTE: Date & initial all entries



D3695-1 SLIDER



SECTION A-A



D3695-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

w/o 56904

RELEASED
09/02/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
DATE	08.11.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

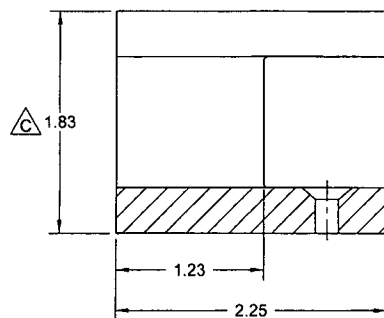
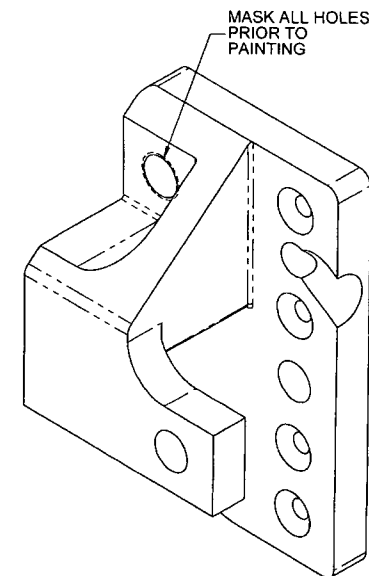
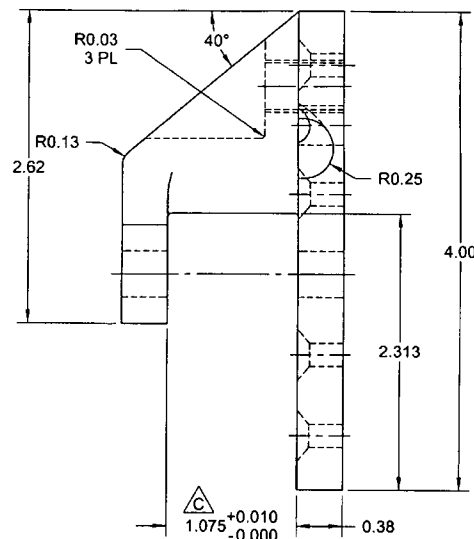
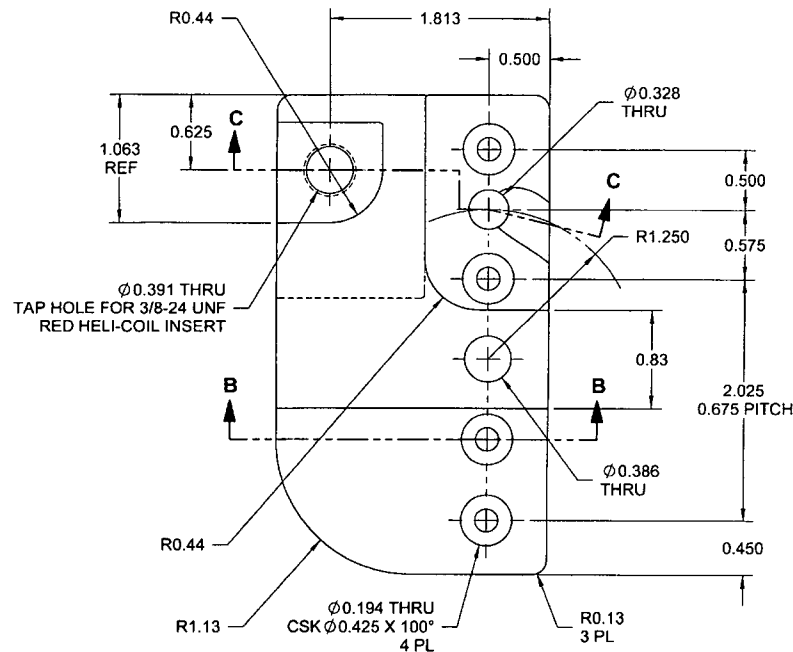
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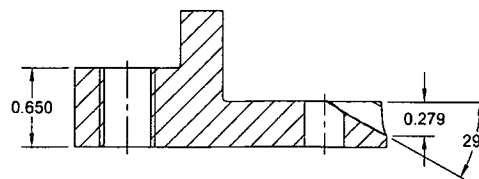
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SECTION B-B









SECTION C-C

D3695-3 STOPPER

RELEASED
 07/02/05 NIP

D3695-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6511/-T6510/-T6511/-T62) BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GREY SANDEX (4.3.5.6) PER DART
 QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3695	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
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